



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D4491-043
Job Sheet 187086



Part No: D4491-043

Job Qty: 1 pcs

Part Name: Door Hinge Assembly, Left Lower



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/27/18

Job Tracking No:

Due Date: 1/31/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A SHEET 1 IPP REV:A NEW ISSUE 11-12-05 JLM VERIFIED BY:DD IPP REV:B 12.01.31 REV.A
DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	1/31/19	1/31/19	0.00	0.00	Start Up Stores/Pkg-1		
100	Packaging 1 - Pick Kit	1 pcs	1/31/19	1/31/19	0.00	0.00	Packaging 1-5		
110	Small Fab - 2 - B4B	1 pcs	1/31/19	1/31/19	0.00	0.00	Small Fab - 1 - B4B		
							Small Fab - 2 - B4B		
							Small Fab - 3 - B4B		DAS
							Small Fab - 4 - B4B		36
							Small Fab - 5 - B4B		9-89
							Small Fab - 6 - B4B		
							Small Fab - 7 - B4B		
120	QC 5	1 pcs	1/31/19	1/31/19	0.00	0.00	QC5		
							QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		DAS
							QC 5 - 38		38
							QC 5 - 42		9-89
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
130	Packaging 3-1 - Stock - B4B	1 pcs	1/31/19	1/31/19	0.00	0.00	Packaging3-2		
							Packaging 3 - 1 - B4B	ST098	JAN 17 2019

				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
140	QC 21 - SA	1 pcs	1/31/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
Part Op 100 - pick kit Descriptions: 110 - Small Fab - ASSEMBLE AS PER DWG 120 - QC5- Inspect part completeness to step on W/O 130 - Identify as per dwg & Stock Location: _____ 140 - QC21- Final Inspection - Work Order Release					DAS 21 8-89
					JAN 17 2019

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D4491-3	Hinge, Left Lower	1 pcs (1 ea)	90-Start up Operation	
D4492-1-ZV	Bushing	1 Ea (1 ea)	90-Start up Operation	
D4493-1-ZV	Hinge Fork	1 Ea (1 ea)	90-Start up Operation	
D4493-2-ZV	Hinge Fork	1 Ea (1 ea)	90-Start up Operation	
D4520-3-ZV	Hinge Shim	1 Ea (1 ea)	90-Start up Operation	
MS21043-08	Nut, Self-Locking	2 Ea (2 ea)	90-Start up Operation	
MS27039C0816	Screw	2 Ea (2 ea)	90-Start up Operation	
NAS1149CN832R	Washer	4 Ea (4 ea)	90-Start up Operation	
POF-40022	Push-On Feet	1 pcs (1 ea)	90-Start up Operation	

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D4491-3	1	1	0
	D4492-1	1	4	0
	D4493-1	1	12	0
	D4493-2	1	10	0
	D4520-3	1	4	0
	MS21043-08	2	86	0
	MS27039C0816	2	27	0
	NAS1149CN832R	4	598	0
	POF-40022	1	190	0
Part Specifications				
Specifications could not be found.				

Plex 1/14/19 10:17 AM Dart.Hadley.Shannon



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D4491-043
Job Sheet 187086



Part No: D4491-043

Job Qty: 1 ea

Part Name: Door Hinge Assembly, Left Lower



Part Weight: 0 lbs

Status: New

Priority: Medium

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					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	1/31/19	1/31/19	0.00	0.00	Start Up Stores/Pkg-1		JAN 1 11 2019
100	Packaging	1 pcs	1/31/19	1/31/19	0.00	0.00	Packaging1-5		
110	Small Fab	1 pcs	1/31/19	1/31/19	0.00	0.00	Small Fab-7		
120	QC	1 pcs	1/31/19	1/31/19	0.00	0.00	QC5		
130	Packaging	1 pcs	1/31/19	1/31/19	0.00	0.00	Packaging3-2		
140	QC21-SA	1 Ea	1/31/19	1/31/19	0.00	0.00	QC21		

Part Op
Descriptions: 110 - ASSEMBLE AS PER DWG

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D4491-3 98	Hinge, Left Lower	1 Ea (1 ea)	90-Start up Operation	896091
D4492-1 99	Bushing	1 Ea (1 ea)	90-Start up Operation	895290
D4493-1 94	Hinge Fork	1 Ea (1 ea)	90-Start up Operation	89614
D4493-2 93	Hinge Fork	1 Ea (1 ea)	90-Start up Operation	89615
D4520-3 100	Hinge Shim	1 Ea (1 ea)	90-Start up Operation	895291
MS21043-08	Nut, Self-Locking	2 Ea (2 ea)	90-Start up Operation	89130505
MS27039C0816	Screw	2 Ea (2 ea)	90-Start up Operation	89122815
NAS1149CN832R	Washer	4 Ea (4 ea)	90-Start up Operation	5045862
POF-40022	Push-On Feet	1 pcs (1 ea)	90-Start up Operation	8920209

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D4491-3	1	2	0
	D4492-1	1	6	0
	D4493-1	1	14	0
	D4493-2	1	12	0
	D4520-3	1	5	0
	MS21043-08	2	90	0
	MS27039C0816	2	32	0
	NAS1149CN832R	4	733	0
	POF-40022	1	188	0

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval				
Description Work Order Deviation				Disposition				Completed By			
				 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL: 1 813 632-5200 Email: sales@dartaero.com www.dartaerospace.com				Job No: 187086 Part: D491-043 Serial No/Batch: S143879 Revision: Inspector: Exp Date: Instructions: Various STCs Date: 01/10/19		Lead hand / Supervisor Approval Verification	
								Container No: S143879		QC / QA Coordinator Approval	
								Barcode:			
Root Cause				FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐				Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
				OTHER : ☐							

Part Specifications
Specifications could not be found.

Plex 11/27/18 12:57 PM Dart.lajeunesse.marie

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								